

Date: Wednesday, 2/15/2006 3:42:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 0H-58 SKIDTUBE ASSEMBLY
 Job Number : 25814A
 Estimate Number : 10475
 P.O. Number : N/A Part Number : D058672041
 This Issue : 2/15/2006 S.O. No. : N/A Drawing Number : D2922 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : A1
 Previous Run : 25813A Material : N/A
 Written By : *See COMMENT Below* Due Date : 3/20/2006 Qty: 1 Um: Each
 Checked & Approved By : *06.02.16*
 Comment : Est Rev:C 02.06.28 Re-format; ECN 258 KJ
 Est Rev:D 06.02.06 Added Dt8025 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD *32449.7 BE 06-02-27 ①*

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube *BE 06-02-27 ①*

2-Cut aft end of D2620 bent tube as per dwg D2922 *123.59 BE 06-02-27 ①*

3-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia. *BE 06-02-27 ①*

4-Drill holes for wearplates using DT 8487 Open to 0.297" dia. *BE 06-02-27 ①*

5-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit *BE 06-02-27 ①*

7-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922 *BE 06-02-27 ①*

8-Deburr and Blow out all chips form inside the tube *BE 06-02-27 ①*

9-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod. *06-02-27*

A/R Aluminum Rod *118839 / m19100 BE 06-02-27 ①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 25814A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BE 06-03-01 (V)

4.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2923

Web

B

25870

BE 06-03-01

(V)

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid)

BE 06-03-01

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid)

BE 06-03-01

3-Deburr and Blow out all chips from inside the tube

BE 06-03-01

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

A/R

Sikaflex-291

M19597

BE 06-03-01

Sikaflex expire date:

06-06-18

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-03-08

Comment: INSPECT WORK TO CURRENT STEP

7.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty

Part Number

Description

Batch

1 D2794

Fwd Cap

B14588

BE 06-02-27

WORK ORDER CHANGES

PROCEDURE CHANGE

Dart Aerospace Ltd

W/O:

DATE STEP

By

Date

Qty

Approval
Chief Eng /
Prod Mgr

Approval
QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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[illegible]

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 25814A

Part Number: D058672041

Job Number:



Seq. #: Machine Or Operation: Description :

8.0 D2649 Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number Description Batch

- 22 D2649 Crossbolt spacer

B24200 BE 06-03-13 (1)

9.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922.(Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

M18839 BE 06-03-13 (1)

3-Grind welds flush as per Dwg D2922

BE 06-03-14 (1)

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

BE 06-03-14 (1)

10.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

PD 06-03-16 / J. Jones

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-07-28

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

3 JC 06-07-31

13.0 D26483 Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

5 D2648-3 Wearpad

D 25904

a.m 06-07-31

Dart Aerospace Ltd
W/O:

WORK ORDER CHANGES

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Job Number: 25814A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-15 Wearshoe

B 24845

15.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-21 Wearshoe

B 20917

16.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2924 Wearshoe

B 22595

17.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 MS27039-1-08 Screw

M 19551

18.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 AN960JD10L Washer

M 100233

a.m. 06-07-31

Dart Aerospace Ltd
W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Drawing Name: D058672041

Job Number: 25814A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

ALS41032130

Insert



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

50-ALS4-1032-130 Insert m-19393
or (see QSI 017)

20.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 D2651-1 Plugs 3 25865

21.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 D2651-3 O-Rings 32 5866

22.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap 322587

23.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw m19551

u-m 86-0703

Dart Aerospace Ltd
W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 06/08/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE ASSEMBLY

Job Number: 25814A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer

~~M100233~~ a.m 06-02-31 ①

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291

Sikaflex expire date: 02-07

M100261

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 02-07

M100261

a.m 06-09-31 ①

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

M101667

Batch:

FC 06 07 31 ①

26.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

DL

06108/01 ①

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

N/A

28.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



C206108/04

Dart Aerospace Ltd
W/O.

WORK ORDER CHANGES

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NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	SHEET 1
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	
A	99.10.14	NEW ISSUE	
A1	# CP 01.08.20	Ø0.640 WAS Ø0.625	

RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP.
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

RECEIVED COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25814

NOBKA
OF HONOLULU
STREET 10 VICTORIA
ONCE WILEY 2P
KELLY 2P
CRD CO. 2P